

FEB 16 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-711-021
Job Sheet 172209



Part No: D412-711-021

Job Qty: 1 ea

Part Name: Vertical Reference Door Modification LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 3/12/18

Created By: Michelle Gagnon-Donovan

Type: **SOLD**

Description:

Note: DWG REV L IPP Rev:A 11.04.07 new issue DD ver:EC IPP Rev:B 14.04.25 ECN14-548 DD ver:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	3/12/18	3/12/18	0.00	0.00	Start Up Stores/Pkg-2			MAR 16 2018
120	Packaging	1 pcs	3/12/18	3/12/18	0.00	0.00	Packaging1-4			MAR 16 2018
130	QC	1 pcs	3/12/18	3/12/18	0.00	0.00	QC4			
140	DC	1 pcs	3/12/18	3/12/18	0.00	0.00	DC			
150	Packaging	1 pcs	3/12/18	3/12/18	0.00	0.00	Packaging3-2			
160	QC21-FG	1 Ea	3/12/18	3/12/18	0.00	0.00	QC21	21	MAR 21 2018	MAR 19 2018

Part Op 140 - Photocopy bluefiles and create labels per PPP D412-711-021 CHG002

Descriptions: 150 - Identify and pack for shipping as per PPP D412-711-021 Location: F9099 PPP rev:



Container No: S052381



Part: D412-711-021

Job No: 172209

Serial No/Batch: S052381

Revision:

Inspector:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/16/18

1579

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-12A	Bolt	1 Ea (1 ea)	90-Start up Operation	
AN3-3A	Bolt	22 Ea (22 ea)	90-Start up Operation	
AN3-4A	Bolt	20 Ea (20 ea)	90-Start up Operation	
AN3-6A	Bolt	26 Ea (26 ea)	90-Start up Operation	
CR3242-4-2	Rivet	34 Ea (34 ea)	90-Start up Operation	
D3802-1-120	Window Seal - 120"	1 Ea (1 ea)	90-Start up Operation	
D412-711-101	Replacement Vertical Reference Window	1 Ea (1 ea)	90-Start up Operation	
D412-761-043	Modified Latch Mechanism, LH	1 Ea (1 ea)	90-Start up Operation	
D4165-1	Doubler	1 Ea (1 ea)	90-Start up Operation	
D4165-11	Door Cover Panel	1 Ea (1 ea)	90-Start up Operation	
D4165-3	Inner Door Panel	1 Ea (1 ea)	90-Start up Operation	
D4165-5	Aft Rib	1 Ea (1 ea)	90-Start up Operation	
D4165-7	Fwd Rib	1 Ea (1 ea)	90-Start up Operation	
D4165-9	Angle	1 Ea (1 ea)	90-Start up Operation	
D4207-1	Window Retainer	1 Ea (1 ea)	90-Start up Operation	
D4207-3	Instrument Window	1 Ea (1 ea)	90-Start up Operation	
D4269-1	Angle	1 Ea (1 ea)	90-Start up Operation	
D4269-3	Angle	1 Ea (1 ea)	90-Start up Operation	
D4269-5	Angle	1 Ea (1 ea)	90-Start up Operation	
D4269-7	Angle	1 Ea (1 ea)	90-Start up Operation	
D4324-011	Armrest Assembly	1 Ea (1 ea)	90-Start up Operation	
D4327-1	Angle	1 Ea (1 ea)	90-Start up Operation	
D4327-3	Angle	1 Ea (1 ea)	90-Start up Operation	
D4385-1	Placard	2 Ea (2 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	135 Ea (135 ea)	90-Start up Operation	
MS20426AD4-3	Rivet	140 Ea (140 ea)	90-Start up Operation	
MS20470AD3-3	Rivet, Universal Head	25 Ea (25 ea)	90-Start up Operation	
MS20470AD4-3	Rivet, Universal Head	90 Ea (90 ea)	90-Start up Operation	
MS21042L3	Nut	24 Ea (24 ea)	90-Start up Operation	
MS21059L3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	
MS21069L08	Anchor Nut	8 Ea (8 ea)	90-Start up Operation	
MS21069L3	Anchor Nut	34 Ea (34 ea)	90-Start up Operation	
MS21071L08	Anchor Nut	1 Ea (1 ea)	90-Start up Operation	
MS21071L3	Anchor Nut	3 pcs (3 ea)	90-Start up Operation	
NAS1149F0332P	Washer	92 Ea (92 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-12A	1	48	0
	AN3-3A	22	272	0
	AN3-4A	20	336	0
	AN3-6A	26	191	0
	CR3242-4-2	34	160	0
	D3802-1-120	1	1	0
	D412-711-101	1	0	0
	D412-761-043	1	2	0
	D4165-1	1	1	0
	D4165-11	1	2	0
	D4165-3	1	2	0
	D4165-5	1	1	0
	D4165-7	1	1	0
	D4165-9	1	1	0
	D4207-1	1	2	0
	D4207-3	1	1	0
	D4269-1	1	2	0
	D4269-3	1	0	0
	D4269-5	1	1	0
	D4269-7	1	0	0
	D4324-011	1	0	0
	D4327-1	1	1	0
	D4327-3	1	2	0
	D4385-1	2	3	0
	MS20426AD3-3	135	6,185	0
	MS20426AD4-3	140	3,142	0
	MS20470AD3-3	25	5,770	0
	MS20470AD4-3	90	735	0
	MS21042L3	24	3,648	0
	MS21059L3	4	201	0
	MS21069L08	8	378	0
	MS21069L3	34	125	0
	MS21071L08	1	144	0
	MS21071L3	3	28	0
	NAS1149F0332P	92	3,742	0
Part Specifications				
Specifications could not be found.				

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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001579	S050647	AN3-12A	Bolt	f153854	ST349	1
001579	S050646	AN3-3A	Bolt	s015688	ST350	22
001579	S050645	AN3-4A	Bolt	s019388	ST350	20
001579	S050641	AN3-6A	Bolt	s000530	ST350	26
001579	S050617	CR3242-4-2	Rivet	s019370	ST318	34
001579	S045371	D3802-1-120	Window Seal - 120"	S045369	ST639	1
001579	S050436	D4165-1	Doubler	s046795	ST236	1
001579	S031544	D4165-11	Door Cover Panel	S031543	ST235	1
001579	S030182	D4165-3	Inner Door Panel	S030180	ST235	1
001579	S031540	D4207-1	Window Retainer	S031539	ST237	1
001579	S050437	D4207-3	Instrument Window	S046756	ST237	1
001579	S029894	D4269-1	Angle	S029893	ST084	1
001579	S048870	D4324-011	Armrest Assembly	S050581	ST459	1
001579	S016048	D4327-3	Angle	S016004	ST237	1
001579	S050427	D4385-1	Placard	S044956	ST088	2
001579	S050424	MS20426AD3-3	Rivet	s018535	GA007	135
001579	S050343	MS20426AD4-3	Rivet	fm137597-7	ST312	140
001579	S050325	MS20470AD3-3	Rivet, Universal Head	f16941	ST310	25
001579	S050320	MS20470AD4-3	Rivet, Universal Head	fm135536-1	ST310	90
001579	S050313	MS21042L3	Nut	s038764	ST303	24
001579	S050310	MS21059L3	Nut Plate	s025740	ST301	4
001579	S050307	MS21069L08	Anchor Nut	f123522-40	ST299	8
001579	S050303	MS21069L3	Anchor Nut	s016903	ST299	34
001579	S050292	MS21071L08	Anchor Nut	f102587-40	ST321	1
001579	S050249	MS21071L3	Anchor Nut	fm137680.0	ST299	3
001579	S050243	NAS1149F0332P	Washer	s020603	ST262	92

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001579	S050647	AN3-12A	Bolt	f153854	ST349	1
001579	S050646	AN3-3A	Bolt	s015688	ST350	22
001579	S050645	AN3-4A	Bolt	s019388	ST350	20
001579	S050641	AN3-6A	Bolt	s000530	ST350	26
001579	S050617	CR3242-4-2	Rivet	s019370	ST318	34
001579	S045371	D3802-1-120	Window Seal - 120"	S045369	ST639	1
001579	S050436	D4165-1	Doubler	s046795	ST236	1
001579	S031544	D4165-11	Door Cover Panel	S031543	ST235	1
001579	S030182	D4165-3	Inner Door Panel	S030180	ST235	1
001579	S031540	D4207-1	Window Retainer	S031539	ST237	1
001579	S050437	D4207-3	Instrument Window	S046756	ST237	1
001579	S029894	D4269-1	Angle	S029893	ST084	1
001579	S051593	D4269-3	Angle	S051168	ST084	1
001579	S051590	D4269-5	Angle	S045341	ST237	1
001579	S051592	D4269-7	Angle	S051364	ST237	1
001579	S048870	D4324-011	Armrest Assembly	S050581	ST459	1
001579	S051591	D4327-1	Angle	S046792	ST237	1
001579	S016048	D4327-3	Angle	S016004	ST237	1
001579	S050427	D4385-1	Placard	S044956	ST088	2
001579	S050424	MS20426AD3-3	Rivet	s018535	GA007	135
001579	S050343	MS20426AD4-3	Rivet	fm137597-7	ST312	140
001579	S050325	MS20470AD3-3	Rivet, Universal Head	f16941	ST310	25
001579	S050320	MS20470AD4-3	Rivet, Universal Head	fm135536-1	ST310	90
001579	S050313	MS21042L3	Nut	s038764	ST303	24
001579	S050310	MS21059L3	Nut Plate	s025740	ST301	4
001579	S050307	MS21069L08	Anchor Nut	f123522-40	ST299	8
001579	S050303	MS21069L3	Anchor Nut	s016903	ST299	34
001579	S050292	MS21071L08	Anchor Nut	f102587-40	ST321	1
001579	S050249	MS21071L3	Anchor Nut	fm137680.0	ST299	3
001579	S050243	NAS1149F0332P	Washer	s020603	ST262	92

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001579	S050647	AN3-12A	Bolt	f153854	ST349	1
001579	S050646	AN3-3A	Bolt	s015688	ST350	22
001579	S050645	AN3-4A	Bolt	s019388	ST350	20
001579	S050641	AN3-6A	Bolt	s000530	ST350	26
001579	S050617	CR3242-4-2	Rivet	s019370	ST318	34
001579	S045371	D3802-1-120	Window Seal - 120"	S045369	ST639	1
001579	F166166-3	D412-761-043	Modified Latch Mechanism, LH		FG020	1
001579	S050436	D4165-1	Doubler	s046795	ST236	1
001579	S031544	D4165-11	Door Cover Panel	S031543	ST235	1
001579	S030182	D4165-3	Inner Door Panel	S030180	ST235	1
001579	S052378	D4165-5	Aft Rib	S052196	ST236	1
001579	S052379	D4165-7	Fwd Rib	S052174	ST236	1
001579	S052380	D4165-9	Angle	S052163	ST237	1
001579	S031540	D4207-1	Window Retainer	S031539	ST237	1
001579	S050437	D4207-3	Instrument Window	S046756	ST237	1
001579	S029894	D4269-1	Angle F165232	S029893	ST084	1
001579	S051593	D4269-3	Angle	S051168	ST084	1
001579	S051590	D4269-5	Angle	S045341	ST237	1
001579	S051592	D4269-7	Angle	S051364	ST237	1
001579	S048870	D4324-011	Armrest Assembly	S050581	ST459	1
001579	S051591	D4327-1	Angle	S046792	ST237	1
001579	S016048	D4327-3	Angle	S016004	ST237	1
001579	S050427	D4385-1	Placard	S044956	ST088	2
001579	S050424	MS20426AD3-3	Rivet	s018535	GA007	135
001579	S050343	MS20426AD4-3	Rivet	fm137597-7	ST312	140
001579	S050325	MS20470AD3-3	Rivet, Universal Head	f16941	ST310	25
001579	S050320	MS20470AD4-3	Rivet, Universal Head	fm135536-1	ST310	90
001579	S050313	MS21042L3	Nut	s038764	ST303	24
001579	S050310	MS21059L3	Nut Plate	s025740	ST301	4
001579	S050307	MS21069L08	Anchor Nut	f123522-40	ST299	8
001579	S050303	MS21069L3	Anchor Nut	s016903	ST299	34
001579	S050292	MS21071L08	Anchor Nut	f102587-40	ST321	1
001579	S050249	MS21071L3	Anchor Nut	fm137680.0	ST299	3
001579	S050243	NAS1149F0332P	Washer	s020603	ST262	92

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D412-761-101 S051977 1X

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Good

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
A ₁	A ₁	A ₁	A ₁	A ₁		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		* D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY
 ** PART OF EA20469-12 FWD RIB ASSEMBLY

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR NTS	
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	PART NUMBER	DESCRIPTION
					22	22	AN3-3A	BOLT
					20	20	AN3-4A	BOLT
					26	26	AN3-6A	BOLT
					1	1	AN3-12A	BOLT
					92	92	NAS1149F0332P	WASHER (OR AN960-10L)
					34	34	CR3242-4-2	RIVET
					135	135	MS20426AD3-3	RIVET
					140	140	MS20426AD4-3	RIVET
					25	25	MS20470AD3-3	RIVET
					90	90	MS20470AD4-3	RIVET
					24	24	MS21042L3	NUT
					4	4	MS21059L3	NUT PLATE
					34	34	MS21069L3	NUT PLATE
					8	8	MS21069L08	NUT PLATE
					3	3	MS21071L3	NUT PLATE
					1	1	MS21071L08	NUT PLATE
						1	204-030-853-125	LH COPILOT DOOR (204-030-853-137/-155)
1							D412-711-111	WIRING HARNESS, 212/412
^B 1							^B D4268-043	INSTRUMENT PANEL, 212/412 (REPLACES EA20469-15-412)
	1						D205-711-113	WIRING HARNESS, 205
	^B 1						^B D4268-041	INSTRUMENT PANEL, 205 (REPLACES EA20469-15-205)
		1					D204-711-115	WIRING HARNESS, 204
		^B 1					^B EA20469-15-204	INSTRUMENT PANEL, 204
			1				D214-711-117	WIRING HARNESS, 214
			^B 1				^B EA20469-15-214	INSTRUMENT PANEL, 214
				1			D212-711-119	WIRING HARNESS, EAGLE SINGLE
				^B 1			^B D4268-047	INSTRUMENT PANEL, EAGLE SINGLE

- (A) IF CUSTOMER PREFERS TO SUPPLY AND MODIFY THEIR OWN DOOR, D412-711-021 SHOULD BE SUPPLIED IN LIEU OF D412-711-041
(B) INSTRUMENT PANEL INCLUDED WITH HARNESS ABOVE

NOTES

1) WIRING HARNESSES:

For Bell 204/205/210 Wiring Harnesses, use drawing D2046904.

For Bell 212 Wiring Harnesses, use drawing D2046903*.

For Bell 214 Wiring Harnesses, use drawing D214-761-511.

For Bell 412 Wiring Harnesses, use drawing D412-711-901.

For Bell 212 modified per SH07-28/SR02831NY use D212-761-224 or D212-761-225 depending on aircraft s/n.

* Despite the note on the drawing, D2046903 is applicable to all 212 aircraft serial numbers

Wiring Harnesses will vary depending on aircraft s/n.

2) D412-711-101 REPLACEMENT WINDOW:

To increase downward viewing clarity, it is acceptable to cut a small section from the replacement window on its downward side per Figure 1 of this document. The cutout can be a maximum of 9.00" wide x 17.00" long (229mm x 432mm), measured along the profile of the replacement window. The corners of the cutout must have a minimum radius of 2" (50mm). The cutout should be located at least 1.0" (25mm) from the flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 1 for reference.

3) D412-711-043 SNAP VENT KIT:

It is acceptable to install a total of up to 2X D3932-1 Snap Vents (available from Dart) onto the D412-711-101 Replacement Window to provide ventilation into the cabin. Refer to Figure 1 for acceptable locations and size of cutouts.

4) It is acceptable to use MS21042L3 nuts to install the window in lieu of anchor nuts shown on D2046901.

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
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